

SOLD



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D4775-1

Job Sheet 172535



Part No: D4775-1

Job Qty: 30 ea

Part Name: Strut Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 3/2/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG REV C SHEET 2 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B
DD VERF:JLM IPP REV:C 14.01.10 AS PER REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	3/1/18	3/1/18	0.00	0.00	Start Up Machining-3		10.50 18/03/18
100	Doosan	30 pcs	3/1/18	3/1/18	0.45	13.22	Doosan		10.50 18/03/18
110	QC	30 pcs	3/1/18	3/1/18	0.00	0.00	QC2 Machining-3		10.50 18/03/18
120	QC	30 pcs	3/1/18	3/1/18	0.00	0.00	QC8 Machining-3		10.50 18/03/18
130	HandFinish	30 pcs	3/1/18	3/1/18	0.00	1.05	HandFinish1		SA 18-3-20
140	QC	30 pcs	3/1/18	3/1/18	0.00	0.00	QC7-4		BR 18-3-21
150	Powdercoat	30 pcs	3/2/18	3/2/18	0.00	0.46	Powdercoat1		BR 18-3-21
155	QC	30 pcs	3/2/18	3/2/18	0.00	0.00	QC3		10.50 18/03/18
160	Packaging	30 pcs	3/2/18	3/2/18	0.00	0.00	Packaging3-2	51357	10.50 18/03/18
170	QC21-SA	30 Ea	3/2/18	3/2/18	0.00	0.00	QC21		10.50 18/03/18

Part Op 100 - 1- Turn as per Folio FB166 Rev: _____ & Dwg D4775 Rev: _____ 2- Tap for 3/8-24 Helical Insert check with GO/
Descriptions: NO GO gauge 3

150 - START TIME: 10.50 O.V.T: 320° FINISH: 11.20

MPB 760

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.625W.125	6061-T6 Round Tube 0.625 X.125W	32.7000 ft (1.09 ea)	90-Start up Operation	

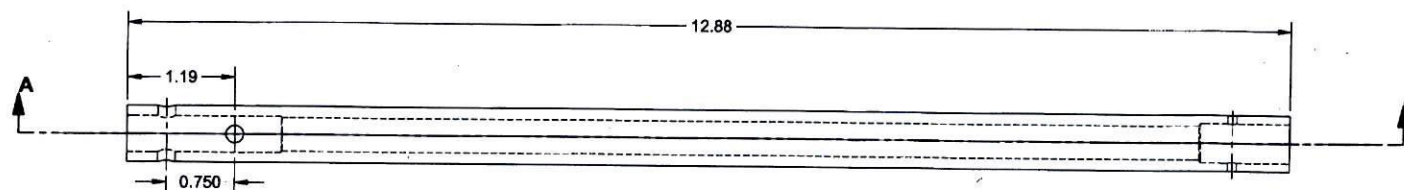
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.625W.125	33	68	0

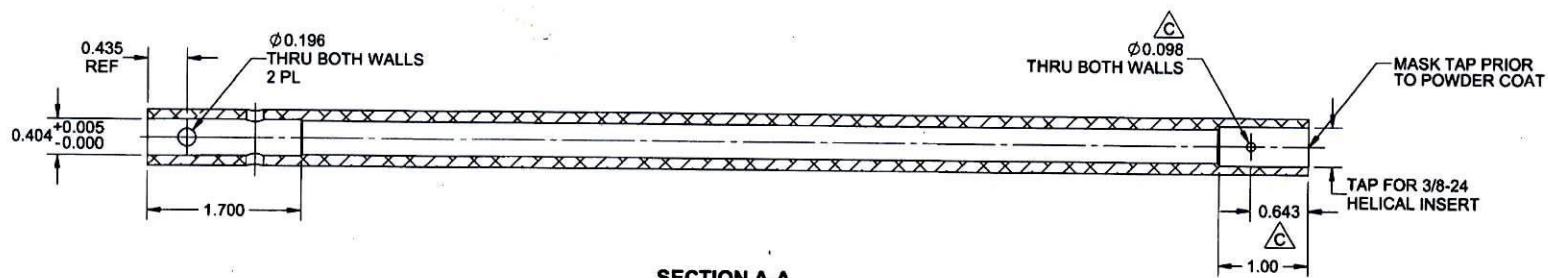
Part Specifications

Specifications could not be found.

Plex 2/20/18 11:28 AM dart.logan.david



D4775-1 STRUT TUBE



SECTION A-A

NOTES:

- 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING, $\phi 0.625 \times 0.125$ WALL
PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
OR AMS 4080 OR AMS 4082 OR AMS 4083
OR ASTM B210 OR ASTM B241
REF DART SPEC M6061T6T0.625W0.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172535
20180220 JL

RELEASED
2014-01-08
WJ

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO. D4775	REV. C
MFG. APPR.		TITLE BASKET STRUT ASSEMBLY	SCALE NTS
APPROVED		COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DE APPR.		DATE 13.11.01	

A

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					



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Container No: S052421



Part: D4775-1

Job No: 172535

Serial No/Batch: S052421

Revision:

Inspector:

Date: 03/17/18